

Date: Monday, 7/9/2007 11:50:48 AM
 User: Kim Johnston

Process Sheet

31

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : GHW MOD KIT
 Job Number : 33390
 Estimate Number : 11182
 P.O. Number : N/A Part Number : D350615041
 This Issue : 7/9/2007 S.O. No. : N/A Drawing Number : D350-615
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : SMALL /MED FAB Drawing Revision : B
 Previous Run : 33256 Material : N/A
 Due Date : 7/30/2007 Qty: 50 100 Um: Each
 Written By :
 Checked & Approved By :
 Comment : Est Rev: Removed Manufacturing 05-12-05 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and type labels (2 GHW Kits per box) as per PPP D350-615-041 CHG003

PER ATTACHED

2.0 33390A "T" HANDLE ASSEMBLY



Comment: Sub-Component "T" HANDLE ASSEMBLY

D2282-041 B 33390 A

ml 07/08/10

3.0 33390B SADDLE ASSEMBLY



Comment: Sub-Component SADDLE ASSEMBLY

D2282-043 B 33832

ml 07/08/10

4.0 D30153 Lock Nut



Comment: Qty.: 3.0000 Each(s)/Unit Total : 300.0000 Each(s)

Pick:

Qty Part Number Description Batch

3 D3015-3 5/16 Locknut

150 257
 1530169

33423

5.0 D30155 SS Nylock Nut 7/16



Comment: Qty.: 1.0000 Each(s)/Unit Total : 100.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3015-5 7/16 Locknut

33263

7/7/12 SD

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GHW MOD KIT

Job Number: 33390

Part Number: D350615041

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

51618015C

SS Bolt 5/16-18 1.5" L



Comment: Qty.: 3.0000 Each(s)/Unit Total: 300.0000 Each(s)

Pick:

Qty Part Number Description Batch

3 5/16-18-015C 5/16 Bolt 1.5 Long

~~250~~ 100
M102977 M103165

7.0

516WC

SS Flat Washer 5/16



Comment: Qty.: 12.0000 Each(s)/Unit Total: ~~1200.0000~~ 600 Each(s)

Pick:

Qty Part Number Description Batch

12 5/16WC 5/16 Flat Washer

M103146

8.0

71614050C

SS Bolt 7/16 5" Long



Comment: Qty.: 1.0000 Each(s)/Unit Total: ~~100.0000~~ 100 Each(s)

Pick:

Qty Part Number Description Batch

1 7/16-14-050C 7/16 Bolt 5.0 Long

-13

M102977 + M105220

9.0

716WC

SS Flat Washer 7/16



Comment: Qty.: 2.0000 Each(s)/Unit Total: 200.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 7/16wc 7/16 Washer

1 D2282-041(Ref) "T" Handdle Assembly

1 D2282-043 (Ref) Saddle Assembly

M105024
M102945
B3339A
B33832

7/7/10 SP

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble D2282-041 with D2282-043 as per Dwg D350-615 Only engage one thread on three 5/16-18-015C bolts

X50

m/07/08/10

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

X50

Er 07/08/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: GHW MOD KIT

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Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-615-041

Location: _____

PPP Rev: E

Handwritten signature and date: 07/08/10 (50)

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Handwritten date: 07.08.13.

Job Completion



Handwritten date: 07/08/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN BW	DRAWN BY KE	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED DIBY	APPROVED BW	DRAWING NO. D350-615	REV. 8 SHEET 1 OF 2
DATE 97.10.21		TITLE GROUND HANDLING WHEEL MOD.	SCALE NTS
A	95.03.23	NEW ISSUE	
B	97.10.21	CHANGE NUMBERING SCHEME	

-041	Part No.	Description
X	D350-615-041	Ground Handling Wheel Mod.
1	D2282-041	"T" ASSEMBLY
1	D2282-043	SADDLE ASSEMBLY
3	5/16-18-015C	5/16 BOLT 1.5 LONG
3	5/16-18NC	5/16 LOCKNUT (D3015-3)
12	5/16WC	5/16 WASHER
1	7/16-14-050C	7/16 BOLT 5.0 LONG
1	7/16-14NC	7/16 LOCKNUT (D3015-5)
2	7/16WC	7/16 WASHER

THESE INSTRUCTIONS ARE TO BE USED IN CONJUNCTION WITH
THE AIRCRAFT MAINTENANCE AND OVERHAUL INSTRUCTION MANUAL
AC43.13.1A & 2A ACCEPTABLE METHODS, TECHNIQUES, AND PRACTICES

INSTALLATION:

1. Remove existing ground handling wheel pump saddle.
2. Replace saddle with D350-615-041.
3. Torque 5/16 bolts to bottom, then back-off half turn to allow easy rotation without excessive play.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 33390

DART

DESIGN	KE	DRAWN BY	KE	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	REV. 8
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D350-615	SHEET 2 OF 2
DATE	97.10.21	TITLE	GROUND HANDLING WHEEL MOD.	SCALE	NTS

D2282-041 "T" ASSEMBLY

7/16-14-050C BOLT (1)
7/16-14NC LOCK NUT (1)
7/16WC WASHER (2)

5/16WC WASHER (REF)

5/16-18-015C BOLT (1)
5/16-18NC LOCK NUT (1)
5/16WC WASHER (4)
(3 PLACES)

EXISTING PUMP
BODY

D2282-043 SADDLE
ASSEMBLY

NO. 3390
WORK ORDER
SUBJECT TO AMENDMENT
WITHOUT NOTICE
ENGINEERING
RETURN TO
SHOP COPY
CONTROLLED COPY

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Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

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07.07.24

2.0 33390A "T" HANDLE ASSEMBLY



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 D2282-041 B _____

3.0 33390B SADDLE ASSEMBLY



Comment: Sub-Component SADDLE ASSEMBLY
 D2282-043 B _____

4.0 D30153 Lock Nut



Comment: Qty.: 3.0000 Each(s)/Unit Total : 300.0000 Each(s)
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 Qty Part Number Description Batch
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5.0 D30155 SS Nylock Nut 7/16



Comment: Qty.: 1.0000 Each(s)/Unit Total : 100.0000 Each(s)
 Pick:
 Qty Part Number Description Batch
 1 D3015-5 7/16 Locknut _____

REFERENCE ONLY